

# Work Order ID 65235

January 10, 2011 10:00:57 AM



Page 1

Item ID:	D4189-041	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Pivot Assembly					
Start Date:	1/10/11	Start Qty: 2.00		Cust Item ID:		
Required Date:	1/28/11	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan: <i>CL</i>	Date: <i>1/10/11</i>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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D4189	<i>PAT PA2</i>								
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100	Pick Kit	0.00							
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Packaging	Memo	0.00							
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Packaging									
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110		0.00							
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Small Fab	Memo	0.00							
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Small Fab	ASSEMBLE AS PER DWG								
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120	QC5- Inspect part completeness to step on W/O	0.00							
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QC	Memo	0.00							
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Quality Control									
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*Jan 11-03-18*



*Jan 11-03-18*

PRELIMINARY ISSUE

*inspect to PA2  
Day only  
8/1/03/18 (42)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

January 10, 2011 10:00:56 AM

Work Order ID: 65235

Parent Item: D4189-041

Parent Item Name: Pivot Assembly



Start Date: 1/10/11

Required Date: 1/28/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-12-14 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4188-7 - 		Manufactured	No			100	Each	0.0000	1	2			
Spring, Pivot													
D4189-1 		Manufactured	No			100	Each	0.0000	1	2			
Pivot													
D4189-3 		Manufactured	No			100	Each	0.0000	1	2			
Roller													
D4189-5 		Manufactured	No			100	Each	0.0000	1	2			
Pin													
D4189-7 - 		Manufactured	No			100	Each	0.0000	1	2			
Pin													

63364 JLM

65349 JLM

B65350 JLM

B65351 JLM

B65502 JLM

WASHER.  
NAS155M04L

2 4 m116093 JLM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

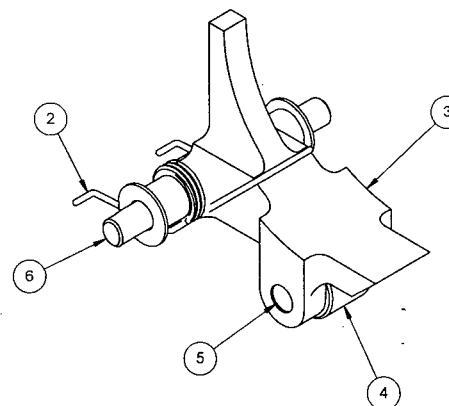
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4189-041	PIVOT ASSEMBLY
2	1	D4188-7	SPRING
3	1	D4189-1	PIVOT
4	1	D4189-3	ROLLER
5	1	D4189-5	PIN
6	1	D4189-7	PIN
7	2	NAS1515M04L	WASHER



**D4189-041 PIVOT ASSEMBLY**

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WITHOUT NOTICE  
WORK ORDER  
NO. 65235

*CL 11/01/10*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

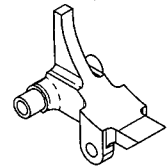
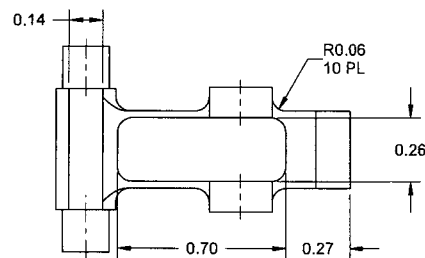
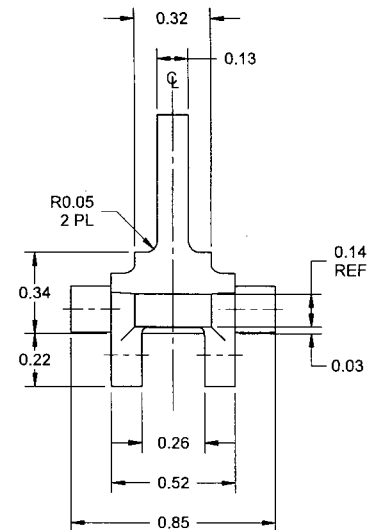
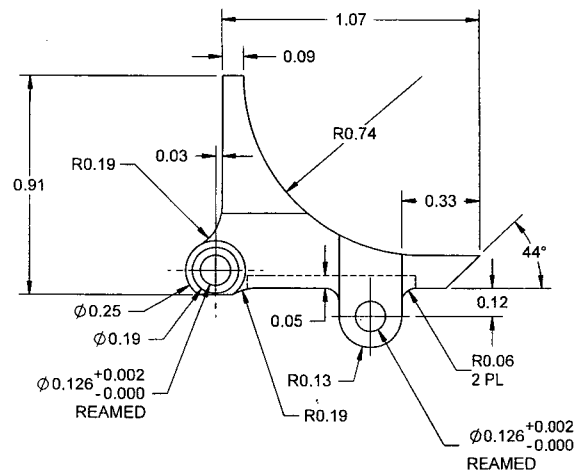
PA2	NEW ISSUE		11.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.01.07		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4189** REV. PA2  
SHEET 1 OF 5

TITLE **PIVOT** SCALE  
NTS

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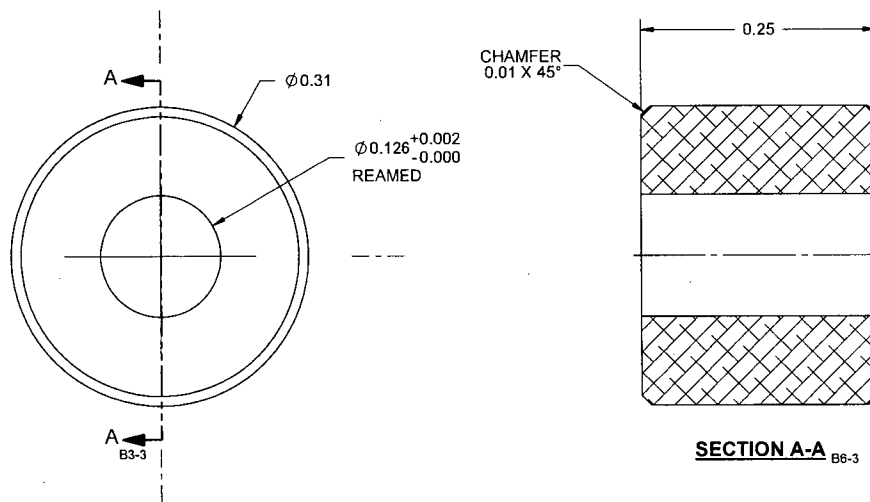
# **D4189-1 PIVOT**

## **NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR  
PER ASTM A276  
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		D4189	SHEET 2 OF 5
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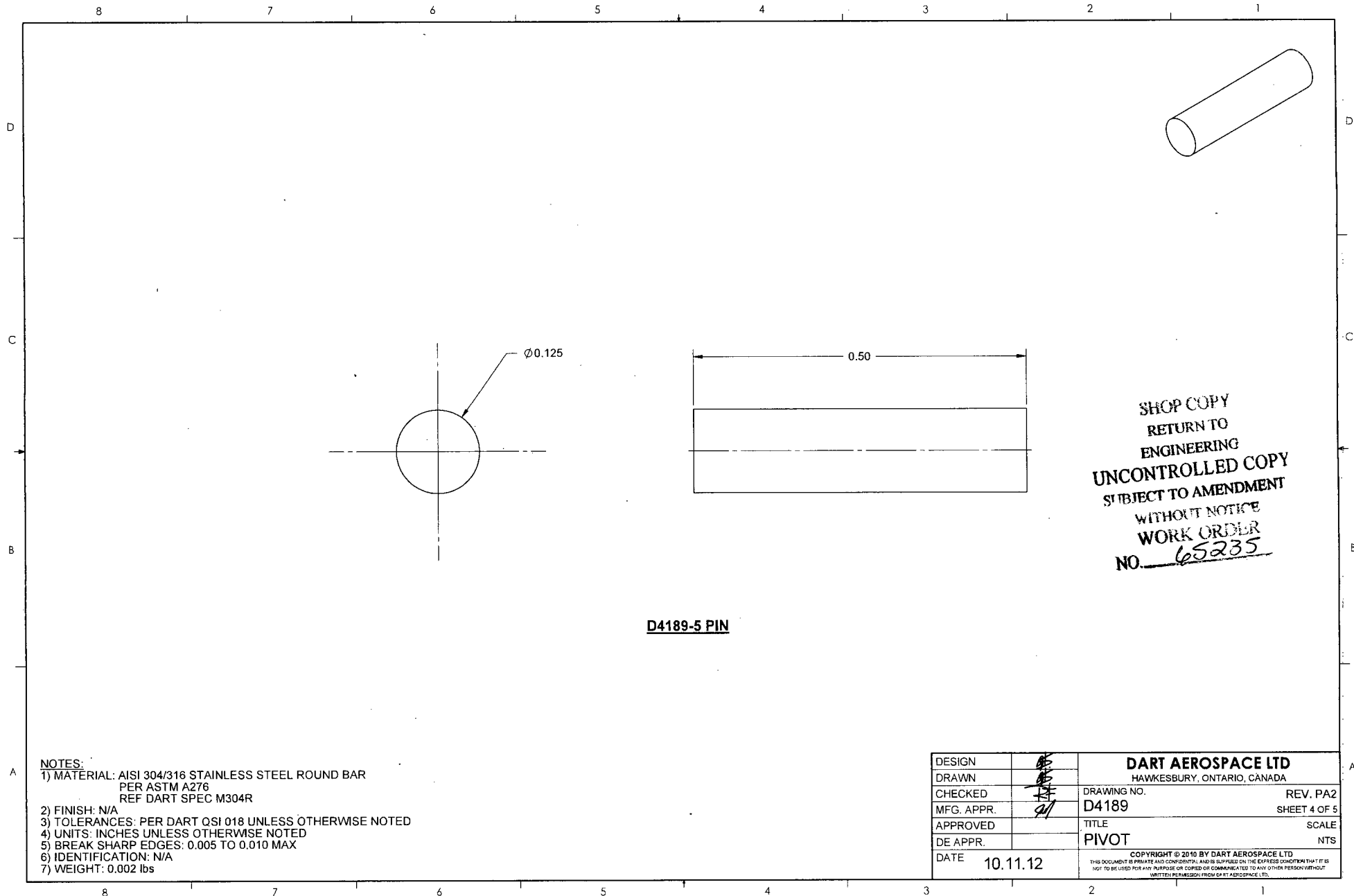
SECTION A-A B6-3

**D4189-3 ROLLER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR  
PER ASTM A276  
REF DART SPEC M304R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.004 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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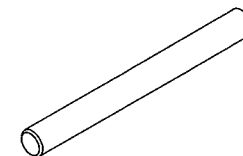
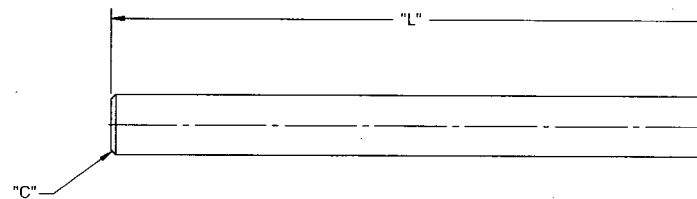
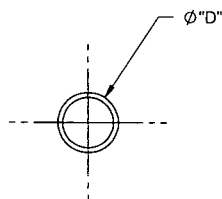
**D4189-5 PIN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR  
PER ASTM A276  
REF DART SPEC M304R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.002 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.	<i>[Signature]</i>	<b>D4189</b>	SHEET 4 OF 5
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# SPECIFICATION CONTROL DRAWING



DART PART NUMBER	DESCRIPTION	SUPPLIER	SUPPLIER PART NUMBER	LENGTH "L"	DIAMETER "D"	CHAMFER "C"
D4189-7	PIN	McMASTER-CARR	97395A453	1.25	0.125	0.01 X 45°

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NO. 65235

D4189-X PIN

- NOTES:
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.004 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. PA2
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